



FIG. 1

10/088036

FIG. 2

2/2

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%123 G71

```
N110 SQL BIND Q1 = 'TOOL.RADIUS'  
N120 SQL BIND Q2 = 'TOOL.LENGTH'  
N130 SQL SELECT LENGTH,RADIUS FROM  
    TOOL WHERE TOOLNUMBER = 2  
N140 T2 DR Q1 DL + Q2  
N150 G17 S1000 M3  
N160 G01 G91 X10 Y100 F200
```

%123 G71